5144

DART AEROSPACE LTD	Work Order:	24408
Description: Hi – Step Leg Assembly	/ Part Number:	D3065-041
Dwg: D3065 Rev. A1 A2	Qty:	60
PF 63.02.17 PF 03.02.28		Page 1 of 2

				Page 1 of	2	
Step	Location	Procedure	1			_
1	DC	Issue Traveller Dug. not required PF 02.11.04	_ ¦By	Date	Qty	<u>_</u>
		(Minimum lots of 30)	K	10.03	3 60	7
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") pluse male	<del>.   ' (</del>	1 00 10 10 2		_
		Material: 2024-T3 Sheet (QQ-A-250/4) - 0.040" thick 75 of	~   ·			
-		(M202413S.040) Batch M17aulo 7	76	05/10/31	75	
3	100	Identify as D3065-1 4,320" 85 32 4 32	٠, ر	93/10131	(2)	
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.320") (1.350")			<b></b>	_
		Material: 2024-13   Sheet (QQ-A-250/4) 0.040"   thick   🍎 😇 41.45	3	1 3 1		
		(M2024T3S.040) Batch M1794g <sup>2</sup> ."-2"	9.6	05/10/3)	60	
4	MV	Identify as D3065-3				
		Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick	1	•		
ľ		(M2024T3S.040)  Batch 17948	1	05/16/31	60	
		Identify as D3065-7	7.6	03/16/31	00	
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8 51") for each log	+	<del></del>		_
		Material: 5052-H32   Sheet (QQ-A-250/8) 0.080"   thick				ı
		(M3032H32S.080) Batch 118710	<b>长</b> .e	05/11/01	120	ŀ
1	1.	Identify as D3065-5				ļ
<u> </u>	1.0.	(Note: make 2 legs per assembly)			100	1
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010)			- CO	٦
	}	Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick				1
		(M5052H32S.080) Batch M14052	Κ.	08/4/23	120	1
,		(Note: make 2 spacers per assembly)	1) 0	בשוחוצם	14 B	
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use			<u> </u>	╛
		stack of 15.	71		60	1
8	MV	Deburr to take measurement	7.	02.11.04	W	4
		•	J.L	05.11.04	60	1
9	QC2	Inspect parts as they come off the CNC machine'	2.0	08.11.01		1
10	000		7.1	05:11-04	60.	l
10	QC8	Second check	/			ĺ
11	MV · f	Moshina Dagger a	3ml	0.5/12/02	<u>(</u>	
' '	IVIV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.			1 4	1
12	MV		J,L	05.11.04	60	
	1	Deburr to take measurement	~ .	3 10 20	/ /	
13	QC2	Inspect parts as they come off the CNC machine	ساء له	05.11.04	60	
	· ·	i provide and points on the older machine	J.h.	05.11.04	60 1	
14	QC8	Second check	J, 12	03.11.04	$\omega$	
- 1 -	3(	1, 1	m	05/1/04	60	
. 15	MV .	Machine D3065-7 as per folio FA181 and Dwg D3065, use		0 - 17107		
16	NA) / 565	stack of 15.	フレ 。	PO-11.20	00	
16	MV 🤲	Deburr to take measurement			7 6	
17	QC2	Inchest ports so they are full only	J.L	05.11.04	$O^{z}$	•
''	QO2	Inspect parts as they come off the CNC machine			(0)	
18	QC8	Second check	J.L	05.11.04 1	Q ()	
			En	sel.	ادر	
19	MV/	Machine D3065-5 as per folio FA179 and Dwg/D3065, use	10	05/11/04	,60	
	/	stack of 10.			/	
				, ,		

75.03.09 Hay

PELEASED 02/11/04 RF r To

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
-									
						-		in a	
	, .		-						

NCR:		; W	ORK OR	DER NON-CONFORMANC	E (NCR)	<del>, , , , , , , , , , , , , , , , , , , </del>		
, ,		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Design Mgr	Approval QC Inspector
	7	-1 stack of 15 scrap		destroy	JL			
11/04	[	stacked marge while			100/10/10		*	
02/		machining P3065-1			Politica			
								-
			-	- 15.450			•-	
		·						
1			•					
				dia .				
						)		

Part No:	PAR #:	Fault Category: NC	CR:	Yes No DQA:	Date:
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

DART AEROSPACE LTD	Work Order:	24408
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Rf 03.02,28		
Dwg: D3065 Rev. At A2	Qty:	60
PF-03:00017		Page 2 of 2

Step	Location	Procedure	I Por	D-4-	T 6:	٦
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use	Ву	Date	Qty	_
·		stack of 10.	121	05.11.06	,_	_20
20	MV	Deburr to take measurement	- 17	02.11.06	100	- 20
		•	21	05.11.06	1,00	-20
21	QC2	Inspect parts as they come off the CNC machine	<del> </del>	102.11.06	1700	-
			21	03.11.06	100	-20
22	QC8	Second check	+-,3	03.11.00	1.00	1
<u> </u>			me	05/12/00	120	
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use				1
0.4	100	stack of 10.	J.L	05.12.02	120	}
24	MV	Deburr to take measurement				1
25	000		J.L	05-12,02	1/20	
25	QC2	Inspect parts as they come off the CNC machine	,	1		1
26	QC8	Coond about	J.L	05.12.02	120	
20	QCo	Second check	<u>_</u>			
27	GA	Doburt D2065 4 D2065 0 D0005 5 (D0005 5)	12 G	05/17/02	130	
۷.	JOA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack.		05/12/04		60
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065	DU	05/12/09	40	
		Deild D3003-1, D3003-3 & D3005-7 as per Dwg D3065		111		
29	QC5	Inspect work to Step 28	13	05/12/08	60	
1.		The poor work to crop 20	12.	5-12-12	60	
30	FP	Chemical conversion coat as per QSI 005 4.1 RF 02.11.06	DL		00	
,		D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	100	05/12/13	40	
31	GA	Assemble as per Dwg D3065 and identify as D3065-041	7.00	00/12/17		/
	-	Assembly.			60/	
		Qty Part Number Description Batch	٠	110		
		1 D3065-1 Spacer B24408		odoil10		
		1 D3065-3 Spacer <u>B 24 408</u>	B	· . W	.	$I/ \setminus$
ĺ		2 D3065-5 Leg ይ 3 4 ላ ዕፕ	X	1011		1001
		1 D3065-7 Spacer 6 24 408		26. K		HIVU
		30 MS20470AD4-4 Rivet <u>円は1子9</u> 44	100			14.
-20	005		5			\ /
32	QC5	Inspect work to Step 31				
22	<u> </u>		1	06-01-12	60	
33	GA	Identify and Stock	/ _ T			
		D3065-041 Hi-Step Leg Assembly D3066-1 Spacer 22 8 / 229		17		
34	AC	D3066-1 Spacer 238/337	/ 0	6/01/13	60	
J-	70	Cost / part		/ /		
35	DC	Close W/O	201-	06.01-16	60	
		Inspect Level 21	İ	]	1	
L		mopoor Lovol 21	ļ			

Rev	Date	Change	Revised By	Approved
Α	01.12.10	New Issue	SM	Approved
В	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
С	02.11.01	Incorporated D3066-1 IPP	KJ R	





## Dart Aerospace Ltd

W/O:		WORK ORDER CHA	ANGES				
DATE	STEP PROCEDURE CHANGE By D				Date Qty	Approval Mfg / Design Mgr	Approval QC Inspector
	37						

NCR:		W	ORK OR	DER NON-CONFORMANCE	(NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	<b>Initial</b> Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector
66.01-11	31	Hole oversized when removing arrivet in MS3065-1, Also 1x03065-5 has a cleep grief mark of a rivet hole after removing a scratch in the motil	anan	Scrapt replace 03065-1 (B 23349) and assemble asper Dwg. Scrap And replace 03065-5 (B23618) and rivets (M17944 Off15) ASSemble as paroug	SB 06/01/12	01-01-12	B 09317	100.00.12
		·						
				·				-
				·				
								,

Part No:	PAR #:	Fault Category:	NCR:	Yes N	No	DQA:	Date:
NOTE: Date & initial all entries	•			QA: N/	C CI	osed:	Date:

D3065-5DART AEROSPACE LTD	Work Order:	24408
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	749				
2.093	+/-0.010	2-093				
3.936	+/-0.010	3.937				
4.186	+/-0.010	H 187				
0.587	+/-0.010	. < 4 4				
Ø0.128	+0.005 -0.000	.130				
R0.125	+/-0.010	.125	/,			
3.465	+/-0.010	3.465				
Ø1.250	+0.005 -0.000	1.252	//			
0.368	+/-0.010	. 368				
0.871 (Pitch)	+/-0.005	. 87/				
	-					
·		-		<u> </u>		
·						

Measured by: 5,6	Audited by:	Prototype Approval:	N/A
Date: 05.11.04	Date: Stuloy	Date:	: 03.10.08

Rev	Date	Change		Revised by	Approved
Α	03.09.22	New Issue	Plo D3065-041	KJ/RF	12



D3065-5DART AEROSPACE LTD	Work Order:	24408
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing	7-1	Actual	Ancort	Deisst	Method of	C
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
1.260	+/-0.010	1.259				
3.260	+/-0.010	3-261				
5.260	+/-0.010	5.259				
6.520	+/-0.010	6-519				
2.093	+/-0.010	2.094				·
3.936	+/-0.010	3.936				
4.186	+/-0.010	4.185				,
Ø0.128	+0.005/-0.000	- 129				
Ø1.250	+0.005/-0.000	1.252				
Pitch 1.204	+/-0.005	1.205				
X.						
· · · · · ·		-				
			·		, , ,	
					•	

Measured by:	7.L	Audited by:	Er	Prototype Approval:	N/A
Date:	05.11.04	Date:	05/19/04	Date:	N/A ·

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue P/O D3065-041	KJ/RF	01/
В	04.08.12	Removed dimension 1.204	KJ/JLM	[10]

FLEASED

D3065-5DART AEROSPACE LTD	Work Order:	24408
Description: Step Leg	Part Number:	D3065-5
		.*
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.460			Pape	
15.750	+/-0.005	15.750			,	
2.250	+/-0.005	2.250	/	J		
3.460	+/-0.005	3.460				
0.865	+/-0.005	.865	/			
6.020	+/-0.005	6.020	/ .			
1.205	+/-0.005	1.205	/			
3.484	+/-0.005	3,484	/,	,		
0.871	+/-0.005	.871		40, 10		
8.325	+/-0.010	8.330		,		
0.551	+/-0.010	.552		'		
0.213	+0.005/-0.000	,214				711.00
Ø0.128	+0.005/-0.000	0.130				••
				<b>.</b>		•
••••	1.3	jt.		<del></del>		• • • • • • • • • • • • • • • • • • • •
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		,				

Measured by:	2D/3T	Audited by:	<b>B</b> 6	Prototype Approval:	N/A
Date:	05.11.06/05/200	Date:	05.11.06	Date:	N/A

Rev	Date	Change			Revised by	Approved
<b>A</b> :	03.09.22	New Issue	P/O D3065-041	,	KJ/RF	2/
В	04.06.15	Added Ø0.128 dimension			KJ/JLM	ZMI -

RELEASED OY-CO-17/100

D3065-5DART AEROSPACE LTD	Work Order:	24408
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Toterance	Dimension	Accept	Keject	Inspection	Comments
Ø0.128	+0.005/-0.000	.130				
0.865 (Pitch)	+/-0.005	. 865				
4.522	+/-0.010	4.522				
0.250	+/-0.010	.250				
2.093	+/-0.010	2.093				
3.936	+/-0.005	3.936				
4.186	+/-0.010	4.186				
Ø1.250	+/-0.005	1-251				
R0.125	+/-0.010	.125	/			
Grain Direction	N/A					
·						
·						

Measured by: J.L	Audited by:	EP	Prototype Approval:	N/A
Date: 05.11.04	Date:	05/11/64	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	2/
В	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	111

RELEASED

D3065-5DART AEROSPACE LTD	Work Order:	24408	
Description: Spacer	Part Number:	D3066-1	
Inspection Dwg: D3066 Rev: A		Page 1 of 1	

X First Article Prototype

				,		Y
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	./3	1/			
0.708	+/-0.010	705				
0.358	+/0.010	.354	1/			
0.350	+/0.010	350				
2.250 (Pitch)	+/-0.005	2-250				
16.450	+/0.010	16.449				
		1 . es .		*		
	·.	***				
					•	
	1017/01					
						3

Measured by:	Audited by:	me	Prototype Approval:	N/A
Date: 05.12.01	Date:	05/12/02	Date:	03, 10.08

Rev	Date	Change		Revised by	Approved
A	03.09.22	New Issue	P/o :D3065-041	KJ/RF	



#### Job Costing Report

Dart Aerospace Ltd. Hawkesbury Oct 03, 2005 11:23 am

0.00

Work Order No /: 0024408
Project Name : D3065-041 Department Code:

Project For : WK544 Burden Flags : NNNNNNN Work Order Type : Main WO Status : Open

Main WO Number : Invoice State : Not Invoiced House Part Number : D3065-041 Invoice Date :

House Part Number: D3065-041 Invoice Date: Description: Step Leg Assembly Invoice Number:

Manufactured: Yes Invoice Amount:
Amount Req'd: 60

Amount Done : 0 Order Entry No :

Start Date : 10-03-05 OE Value : 0.00

Est Finish Date : 11-05-05

Act Finish Date : Est Mark Up : 0.000%

Act Finish Date : Est Mark Up : 0.000% Drawings Reqd : No Actual Mark Up : 0.000% Ok for Approval :

Approval Rec'd : \$0' Posted to Finished Goods

<i>₹</i>	Estimated	Actual	Var. %	% Posted ,	To Post
Material Cost	: 0.00	0.00	¿0.00	0.00	0.00
Engineering Hours	: ~0.00	0.00	<b>₩</b> 0.00		<b>,</b> .
Engineering Cost	: 0.00	. 0.00	0.00	0.00	. 0.00
Production Hours	: 0.00	0.00	0.00		1
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		f
Packaging Cost	: 0.00	0.00	0.00	0.00	+ 0.00
OverHead Hours	: 0.00	0.00	0.00		\$ 44°
OverHead Cost	: 0.00	- 0.00	0.00	0.00	0.00
CNC Hours	: 0.00	Øz. 00	0.00	Ť .	+
CNC	: 0.00	. V.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		1 June 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Misc.	: 0.00	0.00	0.00	0.00 . 5	0.00
	=======================================	=======	======		
Burden	: , 0.00	0.00	0.00		رهم .
•	=======================================	=======	======	*	•
Total Cost ,	: 0.00	0.00	0.00	<u>%</u> **	
Mark up	: 0.000	0.000	<b>X</b>	- <b>4</b> 6° K	
Selling Cost	: 0.00	0.00	***	*.	
•			· • • •		

Labour Hrs/Amount Done: 0.00 0.00
Profits/(Loss): 0.00 0.00